

CLAIMS

We claim:

1. A method of double color-molding a key top, comprising the steps of:
performing a first shot for injection-molding a light-permeable resin layer, onto
5 which a convex pattern corresponding to a planar shape of a closed loop in a letter,
figure, sign, or the like, is transferred; and
performing a second shot for injecting light-shielding resin from a back side of
said key top into both said outer part and said inner part of said closed loop, which are
defined by said convex pattern, to injection-mold said outer part that forms an outer
10 line of said closed loop and said inner part that forms an inner line of said closed loop.
2. A method of double color-molding a key top, comprising the steps of:
closing an upper metal mold for a first shot including a core that has a
concave portion with a concave pattern corresponding to a planar shape of a closed
15 loop in a letter, figure, sign, or the like, and that has a gate hole for injecting
light-permeable resin, and a lower metal mold having a cavity for injecting
light-permeable resin;
performing a first shot for injecting light-permeable resin into a space
remaining between said core of said upper metal mold and said cavity of said lower
20 metal mold through said gate hole to injection-mold a light-permeable resin layer;
changing said upper metal mold for a first shot to an upper metal mold for a
second shot including a gate hole for injection-molding with the light-shielding resin
each of an outer part that forms an outer line of a closed loop and an inner part that
forms an inner line of said closed loop;
25 closing said upper metal mold for a second shot and said lower metal mold;
and

performing a second shot for injecting light-shielding resin into a space remaining between a core of said upper metal mold for a second shot and said cavity of said lower metal mold through said gate hole to injection-mold said outer part and said inner part on a back surface of said light-permeable resin layer.

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3. A depth of said concave portion formed on said core of said upper metal mold for a first shot is preferably no less than half of a thickness of said inner part or said outer part.